

Date: Tuesday, 27/01/2009 11:09:30 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : BACKER PLATE
Job Number : 45242	
Estimate Number : 11803	
P.O. Number :	Part Number : D25283
This Issue : 27/01/2009 S.O. No. :	Drawing Number : D2528 REV C1
Prsht Rev. : NC	Project Number : N/A
First Issue : 27/01/2009 Type : SMALL /MED FAB	Drawing Revision : C1
Previous Run : 40471	Material :
Written By :	Due Date : 06/02/2009 Qty: 4 Um: Each
Checked & Approved By : <u>JD 09.01.27</u>	
Comment : Est:C 00.06.26 Removed P/O for powder coat EC Est Rev:D 08-07-23 now made on water jet DD verified by:EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M5052H32S063	5052-H32 .063 Sheet
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Comment: Qty.: 0.0319 sf(s)/Unit Total : 0.1277 sf(s)

5052-H32 .063 Sheet

Material: 5052-H32 Sheet (QQ-A-250/8) 0.063" thick

(M5052H32S.063)

Batch: 107076 IB 9-2-9

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET

1-Cut as per Dwg D2528

Dwg Rev: C1

Prog Rev: C1

2-Deburr if necessary

IB 9-2-9

M-1

09/02/09

(9)
(9X)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

IB 9-2-9

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

502/02/09 (XS)

5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

F2 09/02/09

(9)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 11:09:30 AM
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Process Sheet

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Drawing Name: BACKER PLATE

Job Number: 45242

Part Number: D25283

Job Number:



Seq. #:	Machine Or Operation:	Description :
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6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M 109996

START TIME:

9:00

OVEN TEMPERATURE:

326°

FINISH TIME:

9:30

Ref 09-02-10

(9)

7.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION
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Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-02-10

(9)

8.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

5725 Ref 09/2/10 (9)

9.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

09/02/11

Job Completion



MF 09-02-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

FIRST ARTICLE INSPECTION CHECKLIST

x

X

DART

DESIGN <i>KE</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2528	REV. C SHEET 1 OF 1
DATE 98.12.10		TITLE BACKER PLATE	SCALE 1:1
A	96.12.12	NEW ISSUE	
B	97.10.10	CHANGE SIZE AND HOLE LOCATION	
C	98.12.10	ADD D2528-1 AND -3 (TSR A1037) UPDATED TOLERANCES	
C1	05 04.27	1.46 WAS 1.460 ; 1.00 WAS 1.000	

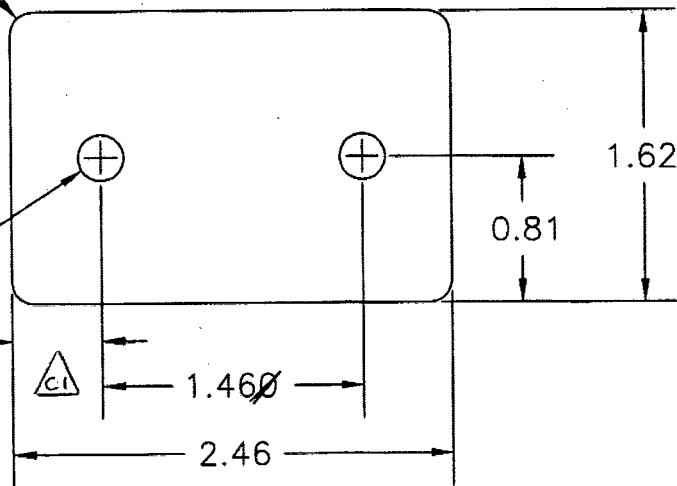
RELEASED
98.12.11 *KE*

R0.13 (TYP)

UNDER REVIEW*01/03/27*
01/03/27

Ø0.257 (TYP)

0.50

D2528-1

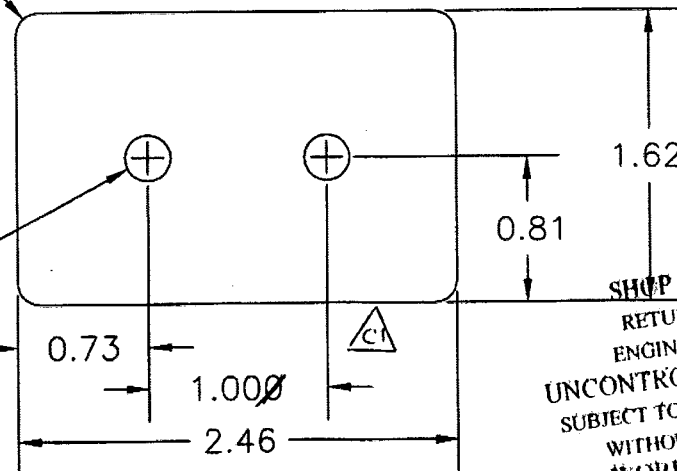
R0.13 (TYP)

Ø0.257 (TYP)

0.73

1.00

2.46

D2528-3

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. *45240*

MATERIAL: 5052-H32 OR 5052-H34 (QQ-A-250/8) OR 2024-T3
(QQ-A-250/4) OR 6061-T6 (QQ-A-250/11) 0.063 THICK
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (REF 4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED